



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

-647.7308

Job Sheet 194698



Part No: 647.7308

Job Qty: 1 pcs

Part Name: EC135 T3/P3 Cable Cutters (Removable Provisions Only)



Order 16177

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/19

Job Tracking No:

Due Date: 6/4/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV N/C SHEETS 38-40

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	6/4/19	0.00	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23	PS.	
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		
							Packaging 1 - 32		
							Packaging 1 - 33		
							Packaging 1 - 34		
							Packaging 1 - 35		
							Packaging 1 - 36		
120	QC 4	1 pcs	6/4/19	0.00	0.00		QC 4 - 28		Sms 19/5/29
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S180836

Part: 647.7308

Job No: 194698

Serial No/Batch: S180836

Revision: NC

Inspector:

Exp Date:

Instructions:

Date: 05/13/19

130	Packaging 3-1 - Stock - B4B	1 pcs	6/4/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	SMB
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	DAS
135	DC - 1 - B4B	1 pcs	6/4/19	0.00	0.00	DC - 1 - B4B	21 MAY 29 2019
						DC - 2 - B4B	2-58
140	QC 21 - FG	1 pcs	6/4/19	0.00	0.00	QC 21 - FG - 21	21 MAY 29 2019
						QC 21 - FG - 70	DAS
						QC 21 - SA - 53	21
Part Op 110 - Packaging1-1 (Pick Kit) Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness) 130 - Packaging3-1 (Identify as per dwg & Stock Location: <u>FG102</u>) pack for shipping as per PPP MPP-195 (647.7308) Packaging3-1 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP MPP-195 (647.7308) 135 - DC (Document Control) Photocopy bluefile & type labels per PPP MPP-195 (647.7308) 140 - QC21 (QC21- Final Inspection - Work Order Release)							

19/5/29

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40
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11/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
601.3011	P-Seal	1.4000 ft (1.4 ea)	110-Packaging 1 - Pick Kit	5006186
647.7501	Lower Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5161694
647.7702	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5143558
647.7701	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5132792
647.0112	Strut Bracket	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5162314
MS21266-2N	Grommet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5129988 x4 5157417 x1
AN44-12A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5134710
AN665-34R	Clevis	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5151964
AN3-11A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5152086
AN4C7A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5152644
NAS6603-12	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5008044
NAS6603-16	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5155974
MS21042-3	Nut use MS21042L3 per QSI 017	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5144952
MS21042L4	Nut	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5158232
AN316C4R	Nut, Jam	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5133882
MS27039-08-13	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5123934
NAS1149FN832P	Washer	23 Ea (23 ea)	110-Packaging 1 - Pick Kit	5134702
NAS1149F0332P	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5150462
NAS1149C0432R	Washer	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5155658
NAS1149F0532P	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	F180057-4
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5139652
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5142190
MS27039-08-19	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5115625
MS21042L08	Nut	9 Ea (9 ea)	110-Packaging 1 - Pick Kit	5157102
647.1702	Skid Deflector Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5141464
LN9025-0820K	Lock Tab Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5141276
LN9037-08018	Screw	8 pcs (8 ea)	110-Packaging 1 - Pick Kit	5099328
93635A212	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5051320
601.3902	Eye Bolt	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5114848
647.1405	EC135 Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5146084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.1012	1	21	0
	601.2045	1	24	0
	601.3011	1	122	0
	601.3902	2	34	0
	647.0112	4	67	0
	647.1405	1	3	0
	647.1702	2	5	0
	647.7501	1	3	0
	647.7701	2	2	0
	647.7702	2	8	0
	93635A212	4	58	0
	AN3-11A	4	303	0
	AN316C4R	4	30	0
	AN44-12A	2	18	0
	AN4C7A	4	151	0
	AN665-34R	4	46	0
	LN9025-0820K	8	87	0
	LN9037-08018	8	82	0
	MS21042-3	4	575	0
	MS21042L08	9	922	0
	MS21042L4	4	3,280	0
	MS21266-2N	8	25	0
	MS27039-08-13	4	430	0
	MS27039-08-19	5	591	0
	NAS1149C0432R	12	1,532	0
	NAS1149F0332P	8	4,847	0
	NAS1149F0532P	2	1,452	0
	NAS1149FN832P	23	2,335	0
	NAS6603-12	4	35	0
	NAS6603-16	4	50	0

Part Specifications

Specifications could not be found.

Plex 5/7/19 1:28 PM Dart.Renwick.Jennifer



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

7308	7305	7307	FIND #	PART #	DESCRIPTION	MATERIAL	SPEC
	4	4	75	601.1604	CHERRY RIVET	CR3213-4-2	
	24	24	76	601.0790	CHERRY RIVET	CR3213-4-3	
	16	16	77	601.1915	CHERRY RIVET	CR3213-4-4	
	8	8	78	601.1183	CHERRY RIVET	CR3213-4-5	
	17	17	79	601.2991	CHERRY RIVET	CR3213-4-6	
	16	16	80	601.2020	CHERRY RIVET	CR3213-5-3	
	12	12	81	601.2481	CHERRY RIVET	CR3213-5-4	
	8	8	82	601.3216	CHERRY RIVET	CR3522-4-3	
	8	8	83	601.3215	CHERRY RIVET	CR3522-5-3	
	2	2	84	601.3136	CHERRY RIVET	CR3212-5-6	
23	2	25	85	601.2764	WASHER	NAS1149FN832P	
8	81	89	86	601.1607	WASHER	NAS1149F0332P	
12		12	87	601.3663	WASHER	NAS1149C0432R	
2	2	4	88	601.3126	WASHER	NAS1149F0532P	
	3	3	89	601.2375	WASHER		
A/R	A/R	A/R	90	600.1012	SEALANT	PR-1425 CLASS B	
A/R		A/R	91	601.2045	RTV	LOCTITE 598	
	A/R	A/R	92	600.0991	MAGNOBOND 6398 PART B		
	A/R	A/R	93	600.0990	MAGNOBOND 6398 PART A		
			94	647.7919	SHIM		
			95	601.1097	WASHER	NAS1149F0463P	
1		1	96	647.5701	GPS MOUNT KIT	FLAG NOTE 6	
	1	1	97	647.7823	CROSS BRACKET AFT		
	1	1	98	647.2114	UPPER U CHANNEL		
			99	647.1404	CUTTER ASSY (UPPER)		
5		5	100	601.3062	SCREW	MS27039-0827	
5		5	101	601.1541	LOCKNUT	MS21042L08	
	4	4	102	601.3212	CHERRY RIVET	CR3523-4-3	
	24	24	103	601.3213	CHERRY RIVET	CR3523-4-4	
	8	8	104	601.3214	CHERRY RIVET	CR3523-5-3	
2		2	105	647.1702	SKID DEFLECTOR ASSY		
8		8	106	601.3655	LOCK WASHER	LN9025-0820K	
8		8	107	601.3654	BOLT	LN9037-08018	
4		4	108	601.3963	BOLT	93635A212	
	2	2	109	601.2910	SCREW	MS27039-1-18	
2		2	110	601.3902	EYE BOLT		
1		1	111	647.1405	CUTTER ASSY (UPPER)		



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Manufacturing Process Procedure
EC-135 CCK Configuration Management

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MPP-195
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Table 20: T3/P3 Cable Cutters Kits

7308	7305	7307	FIND #	PART #	DESCRIPTION	MATERIAL	SPEC
			1	647.7401	UPPER CUTTER ASSY		
1		1	2	647.7501	LOWER CUTTER ASSY		
			3	647.1701	SKID DEFLECTOR ASSY		
	1	1	4	647.1601	WIPER DEFLECTOR ASSY, AFT		
	1	1	5	647.1610	WIPER DEFLECTOR, FWD		
	1	1	6	647.1913	TEE		
	1	1	7	647.1915	SUPPORT ANGLE		
	1	1	8	647.1814	GUSSET, LH		
	1	1	9	647.1815	GUSSET, RH		
2		2	10	647.7702	STRUT ASSY		
2		2	11	647.7701	STRUT ASSY		
	1	1	12	647.1818	NOSE DOOR SPACER		
	1	1	13	647.1810	NOSE DOOR DOUBLER		
4		4	14	647.0112	STRUT BRACKET		
	2	2	15	647.7910	ANGLE BACKET		
	2	2	16	647.7911	BRACKET		
	4	4	17	647.7912	CLIP		
	2	2	18	647.7913	DOUBLER		
	1	1	19	647.7914	BRACKET		
	1	1	20	647.7915	BRACKET		
	2	2	21	647.7916	BRACKET		
	1	1	22	647.7917	BRACKET		
	1	1	23	647.7918	BRACKET		
	1	1	24	647.7819	CROSS BRACKET FWD		
			25	647.7820	CROSS BRACKET AFT		
			26	647.7818	MOUNTING CHANNEL		
	1	1	27	647.7821	EYE BOLT FITTING LH		
	1	1	28	647.7822	EYE BOLT FITTING RH		
	1	1	29	647.1914	BRACKET		
	1	1	30	647.1602	DOUBLER ASSY		
	2	2	31	647.1811	SPACER		
	13	13	32	647.1812	SHIM		
			33	647.2510	SLEEVE		
			34	647.2511	NUT		
	1	1	35	647.3201	GROUNDING CABLE ASSY		
A/R	A/R	A/R	36	601.3011	P-SEAL		

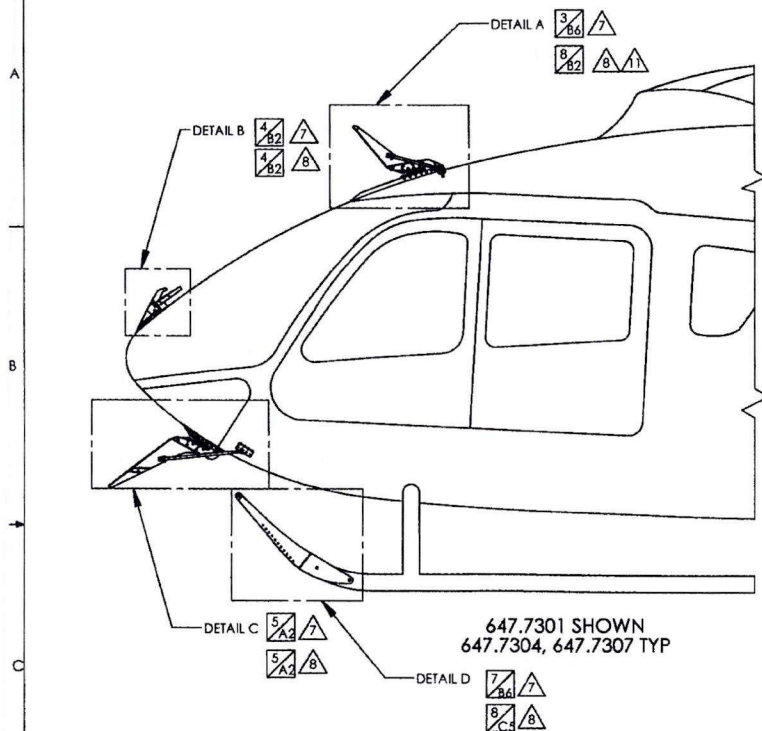


SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

7308	7305	7307	FIND #	PART #	DESCRIPTION	MATERIAL	SPEC
1	1	1	37	601.3007	GROMMET	MS21266-2N	
			38	601.3121	EYE BOLT	AN44-5A	
2		2	39	601.3120	EYE BOLT	AN44-12A	
4		4	40	601.3119	CLEVIS		
	2	2	41	601.3006	CAMLOC RECEPTACLE		
	2	2	42	601.3005	CAMLOC RETAINER		
	2	2	43	601.3004	CAMLOC STUD		
	12	12	44	600.0795	NUTPLATE	MS21047-3	
	2	2	45	601.2823	BOLT	AN3-4A	
4		4	46	601.2826	BOLT	AN3-11A	
	1	1	47	601.1324	BOLT	AN4CH6A	
4		4	48	601.2669	BOLT	AN4C7A	
4		4	49	601.1500	BOLT	NAS6603-12	
4		4	50	601.3130	BOLT	NAS6603-16	
			51	601.3002	BOLT	NAS6604-66	
4	1	5	52	601.2973	LOCKNUT	MS21042-08	
4	31	35	53	601.2943	LOCKNUT	MS21042-3	
4		4	54	601.3209	LOCKNUT	MS21042L4	
4		4	55	601.3128	NUT	AN316C4R	
	20	20	56	647.8510	INSERT		
	4	4	57	647.8511	INSERT		
	2	2	58	647.8512	INSERT		
	4	4	59	601.3127	LOCKNUT	MS21042L5	
	1	1	60	601.2525	SCREW	MS27039-0807	
4		4	61	601.2988	SCREW	MS27039-0813	
			62	601.3137	SCREW	MS27039-816	
	3	3	63	601.2198	SCREW	MS27039-1-07	
	12	12	64	601.3069	SCREW	MS27039-1-09	
	6	6	65	601.1365	SCREW	MS27039-1-10	
	2	2	66	601.1953	SCREW	MS27039-1-12	
	4	4	67	601.1622	SCREW	MS27039-1-14	
	1	1	68	601.3012	SCREW	MS27039-1-15	
	4	4	69	601.2637	SCREW	MS27039-1-16	
	2	2	70	601.1954	SCREW	MS27039-1-17	
	5	5	71	601.2829	SCREW	MS24694S54	
	3	3	72	601.2999	SCREW		
	24	24	73	601.2207	NUTPLATE RIVET	CCR264SS-3-03	
	4	4	74	601.1983	NUTPLATE RIVET	CCR274SS-3-03	

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1			111	647.1405	CUTTER ASSY (UPPER)		
2	2		110	601.3902	EYE BOLT		
2	2		109	601.2910	SCREW	MS27039-1-18	
4	4		108	601.3963	BOLT	93635A212	
8	8		107	601.3654	BOLT	LN9037-08018	
8	8		106	601.3655	LOCK WASHER	LN9025-0820K	
2	2		105	647.1702	SKID DEFLECTOR ASSY		
8	8	8	104	601.3214	CHERRY RIVET	CR3529-5-3	
12	24	24	103	601.3213	CHERRY RIVET	CR3529-4-4	
2	4	4	102	601.3212	CHERRY RIVET	CR3529-4-3	
5	5		101	601.1541	LOCKNUT	MS21042L08	
5	5		100	601.2765	SCREW	MS27039-0819	
			99	647.1404	CUTTER ASSY (UPPER)		
1	1		98	647.2114	UPPER U CHANNEL		
1	1		97	647.7823	CROSS BRACKET AFT		
1	1	1	96	647.5701	GPS MOUNT KIT		
		8	95	601.1097	WASHER	NAS1149PD463P	
		1	94	647.7919	SHIM		
A/R	A/R	A/R	93	600.0990	MAGNOBOND 6398 PART A		
A/R	A/R	A/R	92	600.0991	MAGNOBOND 6398 PART B		
A/R	A/R	A/R	91	601.2045	RTV	LOCTITE 598	
A/R	A/R	A/R	90	600.1012	SEALANT	PR-1425 CLASS B	
3	3	3	89	601.2375	WASHER		
7307	7304	7301	HND #	PART #	DESCRIPTION	MATL	SPEC

ORIGINAL DATE
8-20-DA-191 11/24/09
DRAWN BY
A. QUAN CHICKER
DART APPROVAL
R. BRAYO
01/13/10
CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

DART 3030 ENTERPRISE CT.,
SUITE A
VISTA, CA 92081
(760)-724-5300
APICAL INDUSTRIES, INC.
DBA DART AEROSPACE
EC135 CABLE CUTTERS KIT
REV. D
SCALE NONE SHEET 2 OF 8